

# Work Order ID 86328

June-27-12 12:52:08 PM

Ship July 4

\*86328\*

Page 1

Item ID: D4420-043

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Top Leg Support Assembly

Start Date: 27/06/2012 Start Qty: 5.00

\*5\*

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 5.00

\*5\*

Customer:

Reference:

Approvals:

Process Plan: ML5

Date: 12/06/27

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D4420	B								
110	Pick Kit	0.00							
<b>*110*</b>									
Packaging	Memo	0.00							
Packaging									
120	Gloss Grey (4.3.5.15) per QSI 005 4.3	0.00							
<b>*120*</b>									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <u>8h45</u> OVEN TEMPERATURE: <u>320°F</u> FINISH TIME: <u>9h15</u>								
130	QC3- Inspect Part Finish	0.00							
<b>*130*</b>									
QC	Memo	0.00							
Quality Control									

52

12/06/27

5

SP

12/06/28

5

12-6-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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\*86328\*

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Item ID: D4420-043

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Top Leg Support Assembly

Start Date: 27/06/2012 Start Qty: 5.00

\*5\*

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 5.00

\*5\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

140

0.00

\*140\*

Small Fab

Memo

0.00

Small Fab

1-Assemble as per dwg D4420

150

QC5- Inspect part completeness to step on W/O

0.00

\*150\*

QC

Memo

0.00

Quality Control

160

Identify as per dwg & Stock Location

0.00

\*160\*

Packaging

Memo

0.00

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 86328****\*86328\***

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June-27-12 12:52:08 PM

Item ID: D4420-043

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Top Leg Support Assembly

Start Date: 27/06/2012 Start Qty: 5.00

**\*5\***

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 5.00

**\*5\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170

QC21- Final Inspection - Work Order Release

0.00

**\*170\***

QC

Memo

0.00

Quality Control

12/6/29 MF  
12-06-28

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

June-27-12 12:52:11 PM

Page 1

Work Order ID: 86328

**\*86328\***

Parent Item: D4420-043

**\*D4420-043\***

Parent Item Name: Top Leg Support Assembly

Start Date: 27/06/2012

Required Date: 03/07/2012

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP revA 11.06.30 new issue EC verified by:JLM  
12.03.05 as per dwg rev.b DD verf:EC

IPP revB

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4006-3 Channel		Manufactured	No			110	Each	5.0000	1	5			
<b>*D4006-3*</b>													
				<u>Location</u>			<u>Loc Qty</u>						
				GA			5						
				80627			5						
MS20426AD3-4 <sup>3</sup> RIVET		Purchased	No			140	Each	2,750.000	2	10			
<b>*MS20426AD3-4*</b>													
				<u>Location</u>			<u>Loc Qty</u>						
				ST316			2750						
				104374			236						
				110398			2514						
MS21059L4 Nutplate		Purchased	No			140	Each	58.0000	1	5			
<b>*MS21059L4*</b>													
				<u>Location</u>			<u>Loc Qty</u>						
				ST301			8						
				117887			3						
				119623			5						
				ST302			50						
				121060			50						

*Handwritten signature and date: 12/06/27*

*Handwritten signature and date: 12/06/29*  
*11/2/011 (100)*

*Handwritten signature and date: 12/06/29*

*Handwritten date and circled number: 11/20/30 (52)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

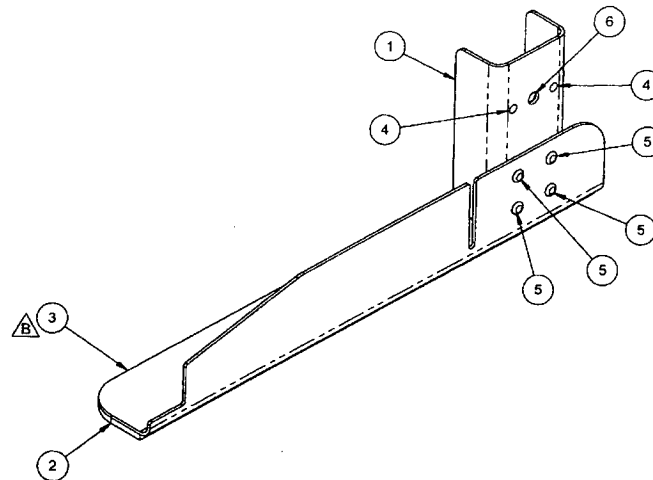
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



ITEM	QTY .041	P/N	DESCRIPTION
	X	D4420-041	TOP SUPPORT ASSY
1	1	D4006-3	CHANNEL
2	1	D4006-5	FOAM
3	1	D4420-1	ANGLE
4	2	MS20426AD3-4	RIVET
5	4	MS20470AD4-5	RIVET
6	1	MS21059L4	ANCHOR NUT



**D4420-041 TOP SUPPORT ASSY**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 86328 MLJ  
12/06/27

RELEASED  
2012-03-02

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3  
BEFORE INSTALLATION OF D4006-5 FOAM AND MS21059-4 ANCHOR NUTS
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4420-041" AND B/N PER QSI 044 6.1
- 7) WEIGHT: 0.38 lbs

B	ADD RELIEFS FOR COMPATIBILITY WITH EUROCOPTER SQUIRREL CHEEK, FINISH WAS "GREY SANDING" (4.3.5.6) (REF. PAR11-123)		MB	12.02.21
A	NEW ISSUE		MB	11.08.22
REV.	DESCRIPTION		BY	DATE
DESIGN	DRAWN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	DRAWING NO.		REV. B	
MFG. APPR.	D4420		SHEET 1 OF 4	
APPROVED	TITLE		SCALE	
DE APPR.	TOP SUPPORT ASSY		NTS	
DATE	12.02.21		COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. NO PART OF THIS DOCUMENT IS TO BE REPRODUCED OR COPIED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

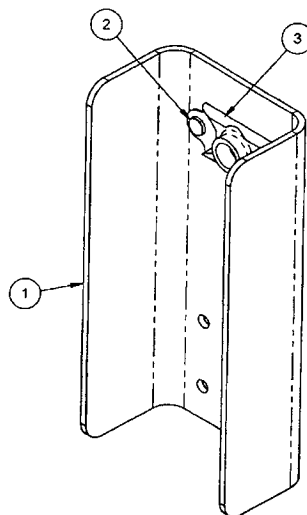
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			


**NOTE:** Date & initial all entries






ITEM	QTY -043	P/N	DESCRIPTION
	X	D4420-043	TOP LEG SUPPORT ASSY
1	1	D4006-3	CHANNEL
2	2	MS20426AD3-4	RIVET
3	1	MS21059L4	ANCHOR NUT



**D4420-043 TOP LEG SUPPORT ASSY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3  BEFORE INSTALLATION OF MS21059-4 ANCHOR NUTS
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4420-043" AND B/N PER QSI 044 6.1
- 7) WEIGHT: 0.09 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4420	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		TOP SUPPORT ASSY	NTS
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86328

RELEASED  
2012-03-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

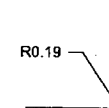
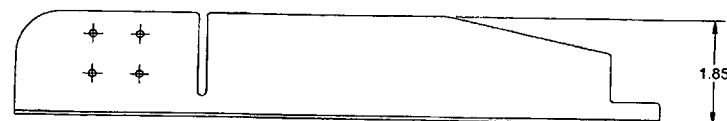
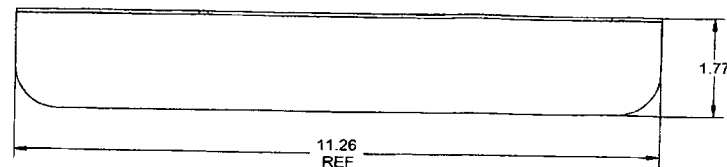
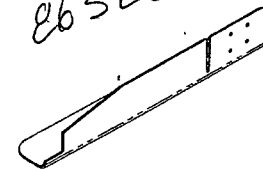
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

86328



**D4420-1 ANGLE**

RELEASED  
2012-03-02

**NOTES:**

- 1) MATERIAL: MADE FROM D4420-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.22 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4420	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		TOP SUPPORT ASSY	NTS
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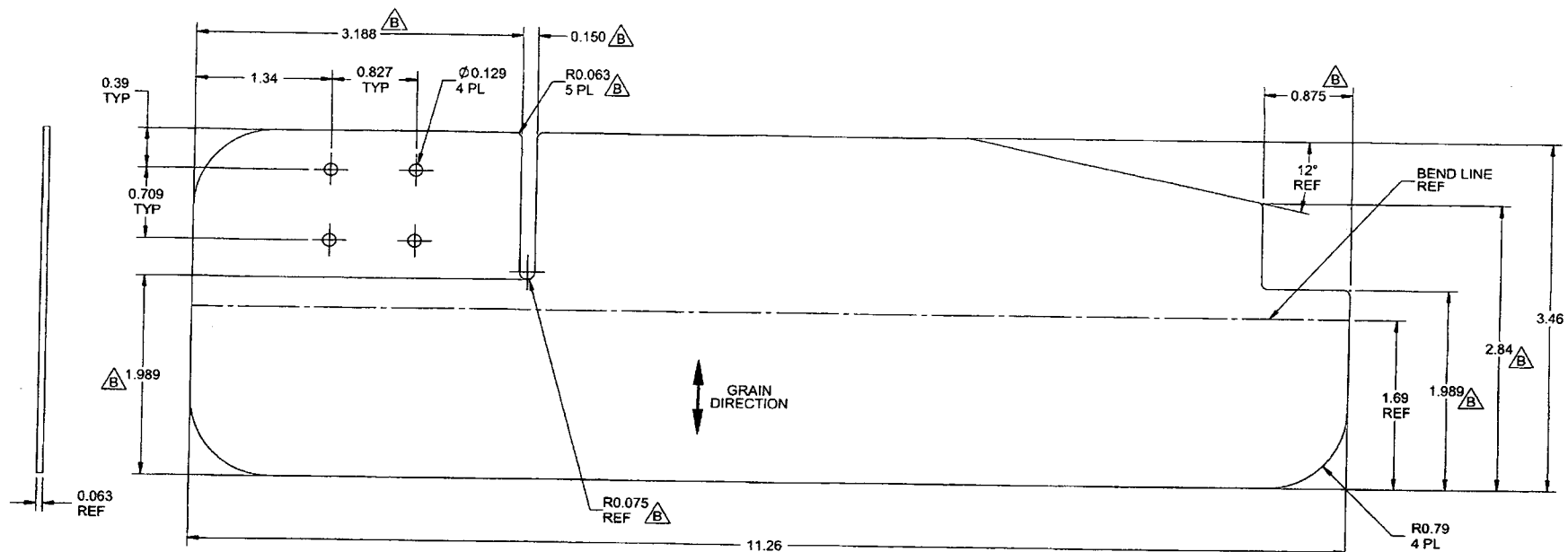
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

96328



D4420-1F FLAT PATTERN

RELEASED  
2012-03-03

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK  
PER QQ-A-250/4 OR AMS-QQ-A-250/4  
OR AMS 4037 OR ASTM B209  
REF DART SPEC M2024T3S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.22 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4420	SHEET 4 OF 4
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